



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

DAS
13
9-89

D2855

Job Sheet 181137



Tel (613) 632-5200

Part No: D2855

Job Qty: 50 ea

Part Name: Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 8/20/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.22 Added receiving step & removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs	8/20/18	8/20/18	0.00	0.00	Purchasing		NOV 08 2018
110	Packaging	50 pcs	8/20/18	8/20/18	0.00	0.00	Packaging2		NOV 08 2018
120	QC	50 pcs	8/20/18	8/20/18	0.00	0.00	QC6		38
130	Small Fab	50 pcs	8/20/18	8/20/18	0.00	2.02	Small Fab-2		Smf
140	QC	50 pcs	8/20/18	8/20/18	0.00	0.00	QC5		NOV 14 2018 DAS
150	Powdercoat	50 pcs	8/20/18	8/20/18	0.00	0.60	Powdercoat1		SEP 18-11-581
160	QC	50 pcs	8/20/18	8/20/18	0.00	0.00	QC3		18-11-219-89
170	Small Fab	50 pcs	8/20/18	8/20/18	0.00	2.02	Small Fab-2		18-11-22
180	QC	50 pcs	8/20/18	8/20/18	0.00	0.00	QC5		18-11-22
190	Packaging	50 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-1		18-11-22
200	QC21-SA	50 Ea	8/20/18	8/20/18	0.00	0.00	QC21		NOV 22 2018

Part Op 100 - Issue P/O: _____ Cast per Dwg D2855 Supplier: Metallurgie SYCA

Descriptions: 110 - Ensure Material Release Note is attached

130 - 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr

150 - START TIME: 2:20

170 - Install Inserts as per Dwg D2855

190 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2855P	Cap	50 pcs (1 ea)	100-Purchasing	5126187
ALS7-1032-225	Insert	100 Ea (2 ea)	170-Small Fab	5039209

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2855P	50	0	0
170-Small Fab	ALS7-1032-225	100	1,048	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S126188



Part: D2855

Job No: 181137

Serial No/Batch: S126188

Revision:

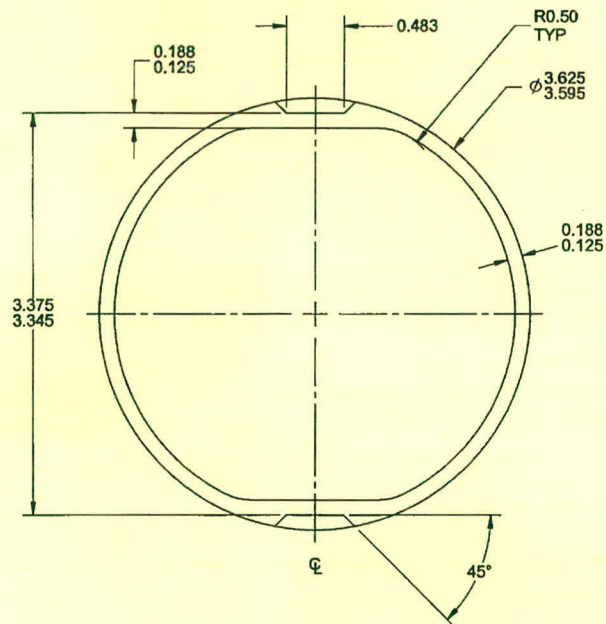
Inspector:

Exp Date:

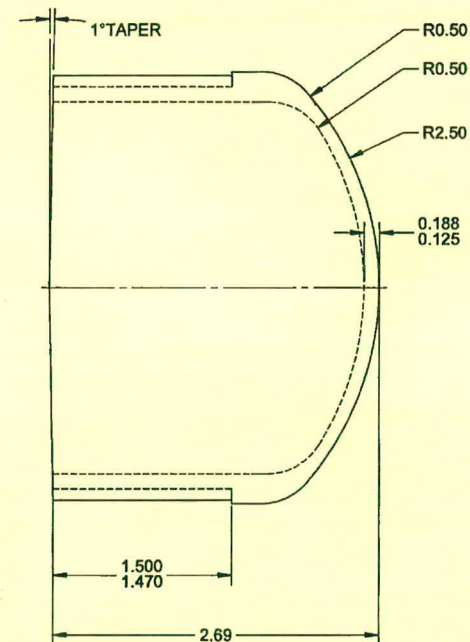
Instructions: Various STC's

Date: 11/06/18

0-80
99
0-80



D2855C CASTING DETAIL CAP



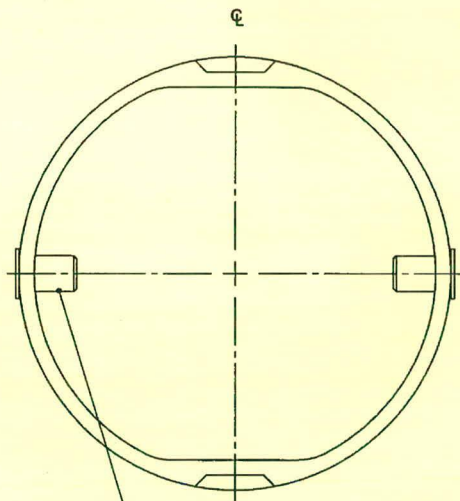
NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

RELEASED
2017-05-08
EN 17-519

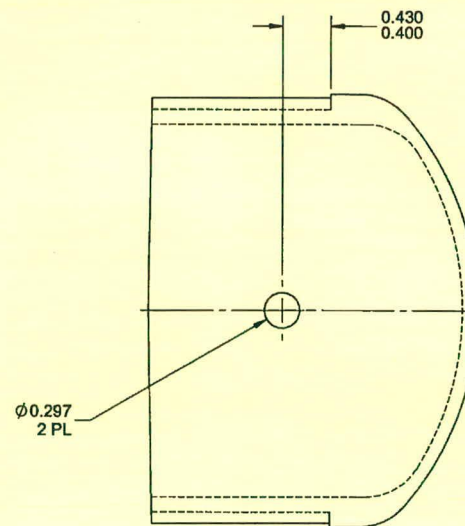
C	ADDED D2855-5 (ZN C8-4)	WK	17.03.01
B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN B6-1, A6-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	06.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2855 CAP COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	WK		
CHECKED	RF		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS	REV. C SHEET 1 OF 4 SCALE NTS	
DATE	17.03.01		

APPROVED



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)



$\phi 0.297$
2 PL

0.430
0.400

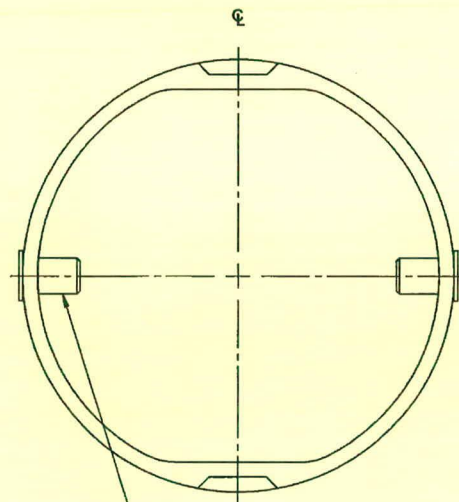
NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
2017-05-08

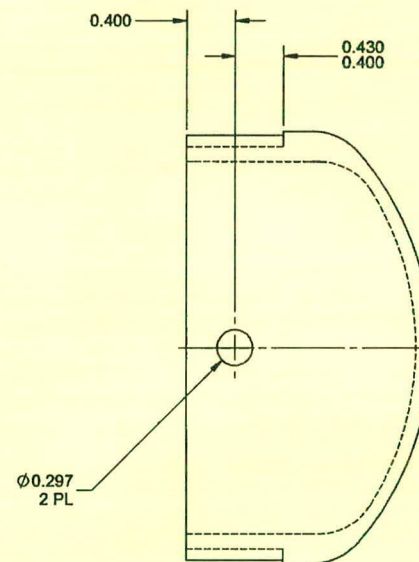
APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP
(MAKE FROM D2855C CASTING)



NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

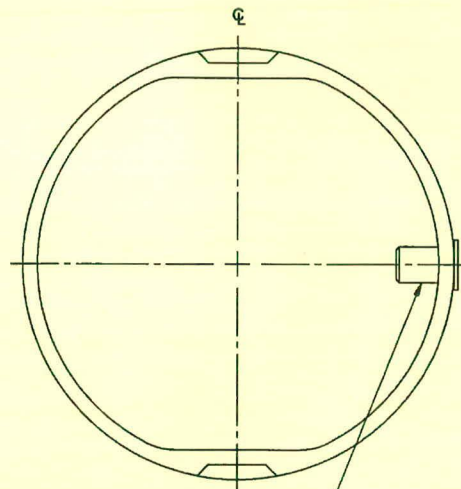
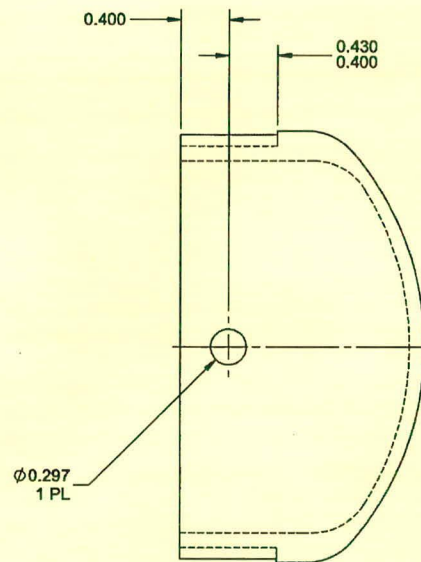
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2017-05-08

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DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DE	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
1 PL

D2855-5 CAP
(MAKE FROM D2855C CASTING) 



NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
DATE	17.03.01	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040563

Supplier: MES001-VC
Metallurgie SYCA
500 Principale,
St.Dominique
QC
JOH 1LO Canada
Phone: 450-261-0853
Fax: 450-261-0894

PO No: PO040563

PO Date: 7/23/18

Due Date: 11/5/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: net 30

Freight Terms:

Special Comments: C OF C IS INCLUDED PRICING OF PARTS.

REVISED

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	181103	D2855P		Cap As per Dwg D2855 Rev. C	Firmed	50	8/20/18	50 pcs	0 pcs	53 pcs	\$15.95093/pcs	\$845.40
Line Item Note W/O 181137												
②	181137	D2855P		Cap As per Dwg D2855 Rev. C	Firmed	50	8/20/18	50 pcs	0 pcs	50 pcs	\$15.95093/pcs	\$797.55
Line Item Note W/O 181103												

Grand Total: \$1,642.95

Order Notes

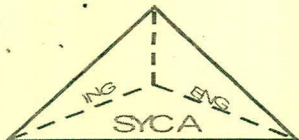
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

CL

Plex 11/8/18 2:42 PM dart.lavoie.chantal



MÉTALLURGIE SYCA Inc.
500, Principale
St-Dominique, Québec
J0H 1L0
Tél: (450) 261-0853
Fax: (450) 261-0894
E-mail: syca@qc.aira.com
WWW.SYCA-INC.COM

OCTOBER 9TH 2018

EXPÉDIER À CETTE ADRESSE:

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY

ON C

K6A 1K7

613-632-9577

NUMÉRO DE COMMANDE:

40563 ✓

QUANTITÉ:

103 ✓

PCES

CODE ET/OU DESCRIPTION:

D-2855 ✓

POIDS:

61

LBS

TRANSPORT:

FEDEX COLLECT

#CONFIRMATION

1 / 1

BARIL

NOTRE NUMÉRO OUR NUMBER	857739
DATE	29 Oct 2018
COMMANDE DU CLIENT CUSTOMER'S ORDER	

VENDU À
SOLD TO
ADRESSE
ADDRESS

Dart Aerospace Ltd
1270 Aberdeen Street
Hawthorn Ont K6A 1K7
647-632-9577

LIVRÉ À
SHIP TO
ADRESSE
ADDRESS

N° D'ENR. DE TAXE
TAX REG. NO.

VENDEUR .
SALESPERSON

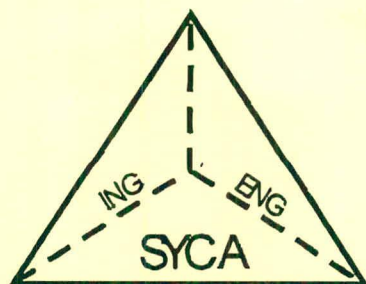
FAB
FOB

**CONDITIONS
TERMS**

VIA

FACTURE - INVOICE

[illegible]



MÉTALLURGIE SYCA Inc.

500, Principale
St-Dominique, Québec
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

WWW.SYCA-INC.COM

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2018-10-29TH

SHIPPING MEMO: 371882

INVOICE NUMBER: 23483

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	103 ✓	D-2855 ✓	40563 ✓

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ15102018

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONNAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101

DAS
38.
9-89

ROUVILLE STATION INC. 1032, BOUL. RICHELIEU RICHELIEU (QUÉBEC) J3L-0L7 TEL : (450) 658-2183 TEL : (450) 658-2808 FAX : (450) 658-1461										
		356SR		Coulée #		120				
ELEMENT:	SI	FE	CU	MG	MN	NI	TI	ZN	CR	SR
ALLIAGE	6.5 - 7.5	.50	.10	.30 - .45	.05	.	.20	.05	.	.
(356.1)										
A356.0		.20	.20	.25 - .45	.10		.20	.10		.007
ANALYSE MOYENNE:	6.79	.14	.031	.44	.01	.03	.10	.017	.006	.003
CHEF DE LABORATOIRE:										
					Date : 2018-05-23					

Q. Langlois

FAXÉ LE
23/08/18

N. 1165

Approuvé S.U.P.

EARL

